

Work Order ID 59186

Thursday, May 27, 2010 1:19:41 PM



Page 1

Item ID:	D3907-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bushing					
Start Date:	5/27/2010	Start Qty:	40.00		Cust Item ID:	
Required Date:	6/4/2010	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-5-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3907	A								

100		0.00							
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	Hardinge	Memo	0.00						
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Hardinge CNC Lathe Small		Machine as per Folio FA823 & Dwg D3907							
		Dwg Rev:							
		folio Rev:							
		Deburr							

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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	QC	Memo	0.00						
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Quality Control									
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10/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 2

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Item ID: D3907-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Bushing
Start Date: 5/27/2010 Start Qty: 40.00  Cust Item ID:
Required Date: 6/4/2010 Req'd Qty: 40.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
						40	8		
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ <i>Basket call</i> Memo	0.00 0.00							
									<i>10/06/21</i> <i>(40)</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
									<i>10/06/22</i> <i>ME</i> <i>10-6-21</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Thursday, May 27, 2010 1:19:45 PM

Page 1

Work Order ID: 59186



Parent Item: D3907-1



Parent Item Name: Bushing



Start Date: 5/27/2010

Required Date: 6/4/2010

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375 		Purchased	No			100	f	35.2400	0.03	1.2			
304 ROUND BAR 0.375													

Location	Loc Qty	Loc Code
MAT	29.9	
111323	0	
114467	12.1	
114676	17.8	
MAT029	5.34	
113325	3.85	
114356	1.49	

1.3 At SH 10/10/20

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

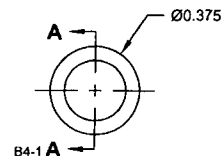
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

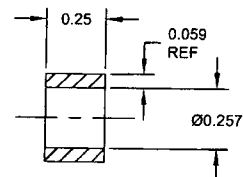
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 59186
PS105-27



D3907-1 BUSHING



SECTION A-A CS-1

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
 REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
 REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
9/10/11

A		NEW ISSUE		AJS	09.03.11
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED		DRAWING NO.	D3907	REV. A	
MFG. APPR.		TITLE	BUSHING (BASKET REPAIR)	SCALE	NTS
DE APPR.					
DATE	09.03.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING BY DART AEROSPACE LTD.			

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